



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66214**

February 7, 2011 1:46:30 PM



Page 2

Item ID: D4329-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Internal Bellcrank Assembly

Start Date: 2/07/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

U 6606-10

Pallet  
on  
D4195-041

POSITIVE RECALL

EFFECTIVE 6-02-08 AUTH

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

RD 344

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 7, 2011 1:46:29 PM

Page 1

Work Order ID: 66214

Parent Item: D4329-041

Parent Item Name: Internal Bellcrank Assembly



Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-02-03 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>D4185-043</del>	<del>D4185-043</del>	Manufactured	No				Each	0.0000		2			
Internal Bellcrank Sub-Assembly		Manufactured	No				Each	0.0000		2			
<del>D4185-3</del>	<del>D4185-3</del>	Manufactured	No				Each	0.0000		2			
Spring Support		Manufactured	No				Each	0.0000		2			
<del>D4185-5</del>	<del>D4185-5</del>	Manufactured	No				Each	0.0000		2			
Fly Stop, Lower		Manufactured	No				Each	0.0000		2			
<del>D4185-7</del>	<del>D4185-7</del>	Manufactured	No				Each	0.0000		2			
Fly Stop, Upper		Manufactured	No				Each	0.0000		2			
<del>D4185-9</del>	<del>D4185-9</del>	Manufactured	No				Each	0.0000		2			
Idle Stop		Manufactured	No				Each	0.0000		2			
<del>D4185-11</del>	<del>D4185-11</del>	Manufactured	No				Each	0.0000		2			
Idle Stop Limiter		Manufactured	No				Each	0.0000		2			
<del>D4185-13</del>	<del>D4185-13</del>	Manufactured	No				Each	0.0000		2			
Spring Pivot Bushing		Manufactured	No				Each	0.0000		2			
<del>D4188-1</del>	<del>D4188-1</del>	Manufactured	No				Each	0.0000		2			
Spring, LH Idle Stop		Manufactured	No				Each	0.0000		2			

B66224

B65651

B66552

B66553

B65654

B65655

B63360

22334

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 66214

Parent Item: D4329-041

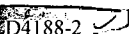


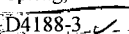


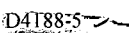


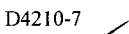











Parent Item Name: Internal Bellcrank Assembly

Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

 D4188-2	Manufactured	No	B63861	Each	0.0000		2									
 Spring, RH Idle Stop																
 D4188-3	Manufactured	No	B63362	Each	0.0000		2									
 Spring, Idle Stop Limiter																
 D4188-5	Manufactured	No	B63363	Each	0.0000		4									
 Spring, Fly Stop																
 D4210-7	Manufactured	No	B65381	Each	0.0000		2									
 Fly Stop Set Screw																
 MS20392-1R21	Purchased	No		Each	4.0000		4									
 Pin																
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST315</td><td>4</td><td></td></tr><tr><td>116823</td><td>4</td><td></td></tr></table>								Location	Loc Qty	Loc Code	ST315	4		116823	4	
Location	Loc Qty	Loc Code														
ST315	4															
116823	4															
 MS20392-1R29	Purchased	No		Each	10.0000											
 Pin																
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST315</td><td>10</td><td></td></tr><tr><td>116635</td><td>10</td><td></td></tr></table>								Location	Loc Qty	Loc Code	ST315	10		116635	10	
Location	Loc Qty	Loc Code														
ST315	10															
116635	10															
 MS21044C08	Purchased	No		Each	0.0000		2									
 nut																

*65381 Jan. 11-08-17*

*116823  
24/11/03-17*

*116635  
2  
116857*

February 7, 2011 1:46:30 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

February 7, 2011 1:46:30 PM

Work Order ID: 66214



Parent Item: D4329-041



Parent Item Name: Internal Bellcrank Assembly

Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

MS24665-136

Purchased

No

Each

140.0000

8



Cotter Pins



2421

Location

Loc Qty

Loc Code

ST309

140

2421

140

Each

0.0000

2

MS51576-4

Purchased

No



Bolt



116976

NAS1515M04L

Purchased

No

Each

100.0000

32



Washer

Location

Loc Qty

Loc Code

ST277

100

116093

100

Each

152.0000

116093

NAS1149DN432J

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST298

152

116702

100

11735

52

11735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

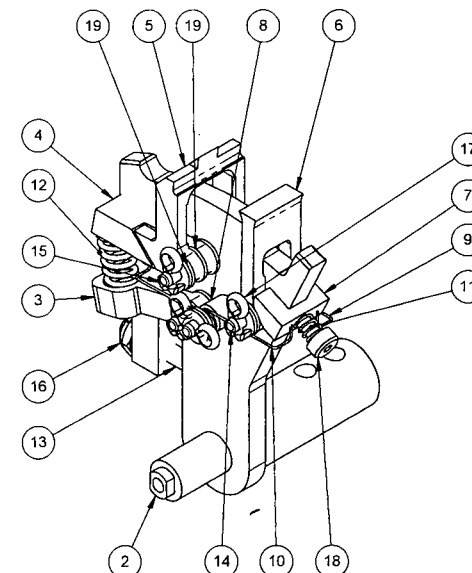
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY.-041	PART NUMBER	DESCRIPTION
1	X	D4329-041	INTERNAL BELLCRANK ASSEMBLY
2	1	D4185-043	INTERNAL BELLCRANK SUB-ASSEMBLY
3	1	D4185-3	SPRING SUPPORT
4	1	D4185-5	FLY STOP - LOWER
5	1	D4185-7	FLY STOP - UPPER
6	1	D4185-9	IDLE STOP
7	1	D4185-11	IDLE STOP LIMITER
8	2	D4185-13	SPRING PIVOT BUSHING
9	1	D4188-1	SPRING - LH IDLE STOP
10	1	D4188-2	SPRING - RH IDLE STOP
11	1	D4188-3	SPRING - IDLE STOP LIMITER
12	2	D4188-5	SPRING - FLY STOP
13	1	D4210-7	FLY STOP SET SCREW
14	2	MS20392-1R21	PIN
15	2	MS20392-1R29	PIN
16	1	MS21044C08	NUT
17	4	MS24665-136	COTTER PIN
18	1	MS51576-4	BOLT
19	16	NAS1515M04L	WASHER
20	4	NAS1149DN432J	WASHER



**D4329-041 INTERNAL BELLCRANK ASSEMBLY**

SHOP COPY<sup>1</sup>  
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 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 66214  
 C21102107

**PRELIMINARY ISSUE**

11.01.31

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.47 lbs

PA1	NEW ISSUE		11.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.01.31		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. PA1 SHEET 1 OF 6	
D4329		SCALE NTS	
INTERNAL BELLCRANK ASSY		NTS	
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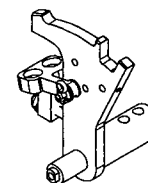
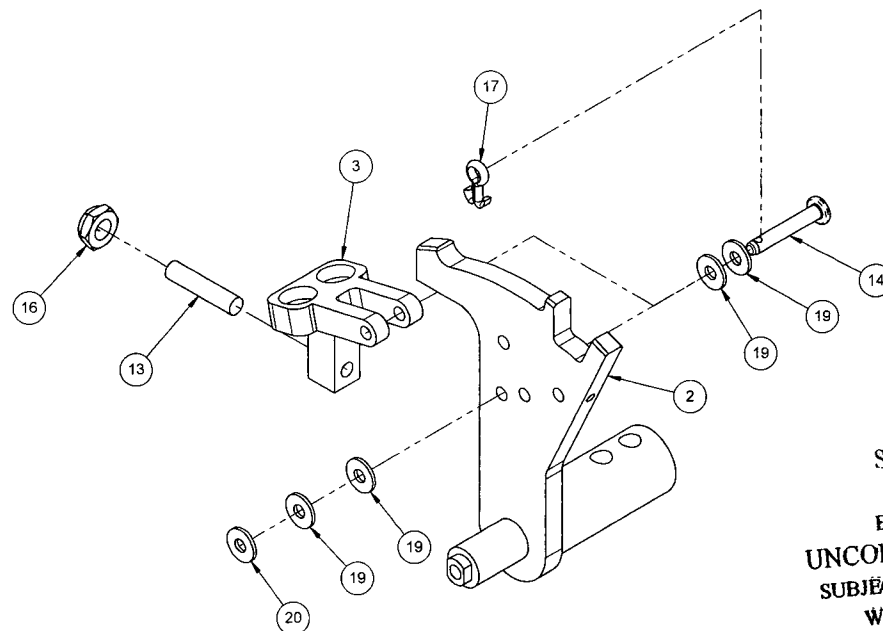
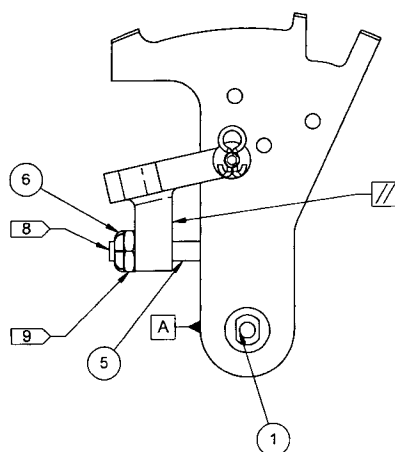
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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WORK ORDER  
NO. 66214

**D4329-041 INTERNAL BELLCRANK ASSEMBLY  
ASSEMBLY - STEP 1**

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
7) WEIGHT: 0.47 lbs  
8) ADJUST D4210-7 SET SCREW (13) TO ACHIEVE PARALLELISM  
9) LOCK SET SCREW BY TIGHTENING MS21044C08 NUT (16)

**PRELIMINARY ISSUE**

11.01.31

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4329</b>	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>INTERNAL BELLCRANK ASSY</b>	NTS
DATE	<b>11.01.31</b>	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

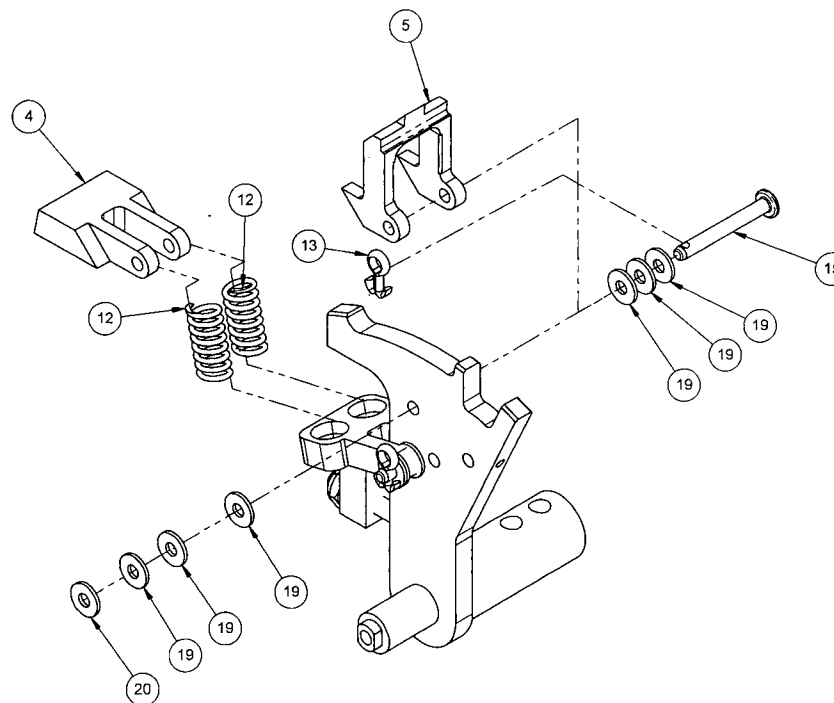
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**D4329-041 INTERNAL BELLCRANK ASSEMBLY  
ASSEMBLY - STEP 2**

**PRELIMINARY ISSUE**

**11.01.31**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.47 lbs

DESIGN	<del>11</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>11</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4329</b>	SHEET 3 OF 6
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W/O:		WORK ORDER CHANGES					
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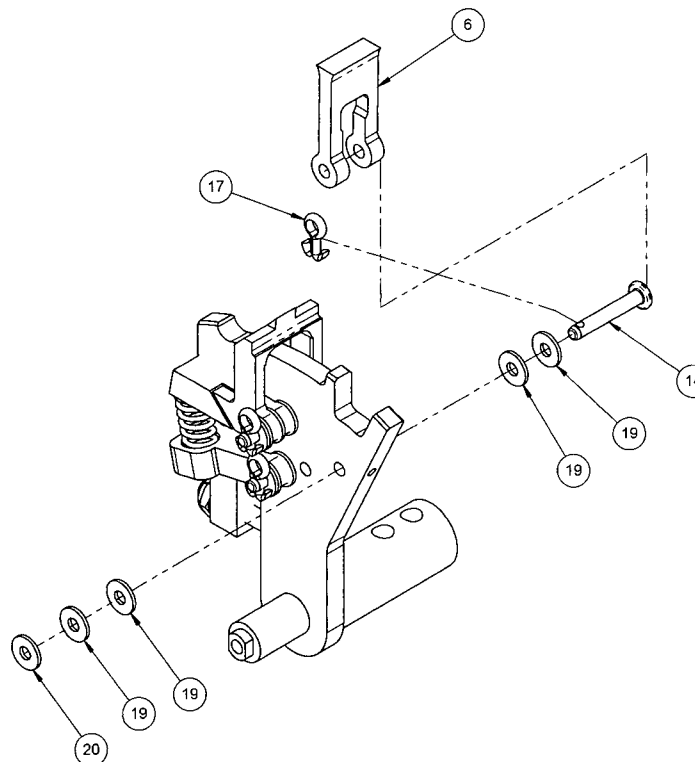
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**D4329-041 INTERNAL BELLCRANK ASSEMBLY  
ASSEMBLY - STEP 3**

**PRELIMINARY ISSUE**

~~11~~ 11.01.31

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.47 lbs

DESIGN	<del>11</del>	<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4329	SHEET 4 OF 6
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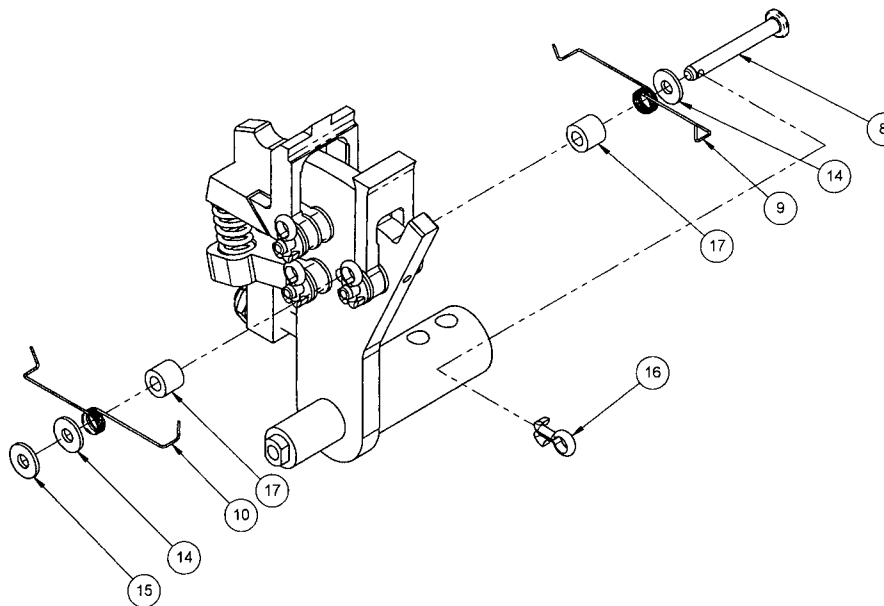
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4329-041 INTERNAL BELLCRANK ASSEMBLY  
ASSEMBLY - STEP 4**

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NO. 66214

**PRELIMINARY ISSUE**

11.01.31

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.47 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		<b>D4329</b>	SHEET 5 OF 6
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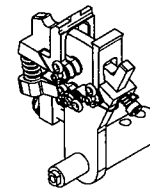
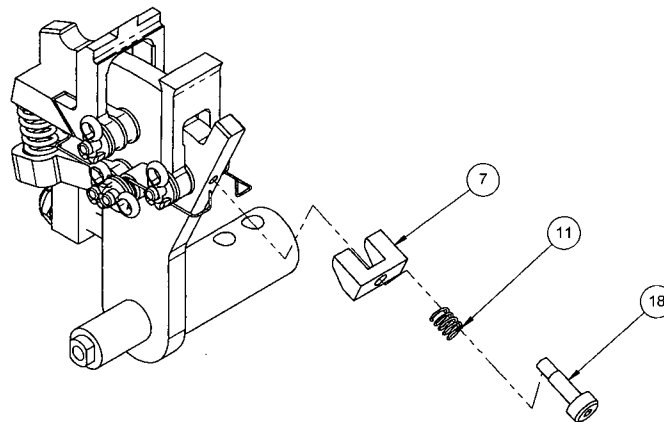
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4329-041 INTERNAL BELLCRANK ASSEMBLY**  
**ASSEMBLY - STEP 5**

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 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 66214

**PRELIMINARY ISSUE**

**11.01.31**

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
 7) WEIGHT: 0.47 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4329</b>	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>INTERNAL BELLCRANK ASSY</b>	NTS
DATE	<b>11.01.31</b>	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries